

Work Order ID 60624

Thursday, July 15, 2010 10:28:26 AM



Page 1

Item ID: D3914-041

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010 **Start Qty:** 1.00

Required Date: 7/22/2010 **Req'd Qty:** 1.00

Reference:

Approvals: Process Plan:

Date: 10-7-15 Tooling:

Cust Item ID:

Customer:

Setup Start

Stop

D Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	A

100 Weld per dwg A/R S.S. rod Batch: H108775 0.00
Large Fab

Large Fab **Memo** 0.00
Large Fab 1- assemble ribs , weld as per dwg D3914 using DT9607A

- 2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
- 3- tack weld mesh on basket as per dwg D3914
make sure to place mesh correctly on lid, check with label plate before tacking mesh

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3914-041**Accept****Revision ID:****Item Name:** Long Basket Lid Assembly (350)**Start Date:** 7/15/2010 **Start Qty:** 1.00**Required Date:** 7/22/2010 **Req'd Qty:** 1.00**Reference:****Approvals:** **Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop****Sequence ID/
Work Center ID**

120



QC

Quality Control

**Operation
Description**

QC5- Inspect part completeness to step on W/O

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

S1010123

OK

130



Powdercoat

Powder Coating

Black Sandtex(Ref.4.3.5.7) per QSI005 4.3

M112588

0.00

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 9:15

Oven Temperature: 320°

Finish Time: 9:45

OK 10-7-26

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 114132 0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

M 10 07 26 O

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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location: 6-A

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

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Page 1

Work Order ID: 60624



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	13.0000	2	2			

Mounting Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	13	
46086	2	
51745	1	
57185	1	
59265	9	

D3914-1

Mounting Bracket	Manufactured	No	100	Each	6.0000	2
------------------	--------------	----	-----	------	--------	---

Rib

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	6	
59295	2	
59926	4	

D3914-7

Rib	Manufactured	No	100	Each	6.0000	2
-----	--------------	----	-----	------	--------	---

Rib

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	6	
59095	2	
59986	4	

AD 10.07.20

AD 10.07.20

AD 10.07.20

AD 10.07.20

AD 10.07.20

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 60624



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

D4016-3



Hinge Half, Lid

Manufactured No

100 Each

7.0000

3



Start Qty: 1.00

Required Qty: 1.00

DD 10.07.20
B60343 -> ②

D4018-5



Rib

Manufactured No

100 Each

48.0000

9



D4020-5



Mesh (350 Basket Long, Lid)

Manufactured No

100 Each

2.0000

1



D4021-3



Data Plate

Manufactured No

100 Each

4.0000

1



DD 10.07.21
B60643 -> ①

DD 10.07.20
B60547 -> ①

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	7	
58737	1	
59744	6	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	48	
58669	12	
59929	36	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	2	
59601	2	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	4	
56050	1	
59054	1	
59987	2	

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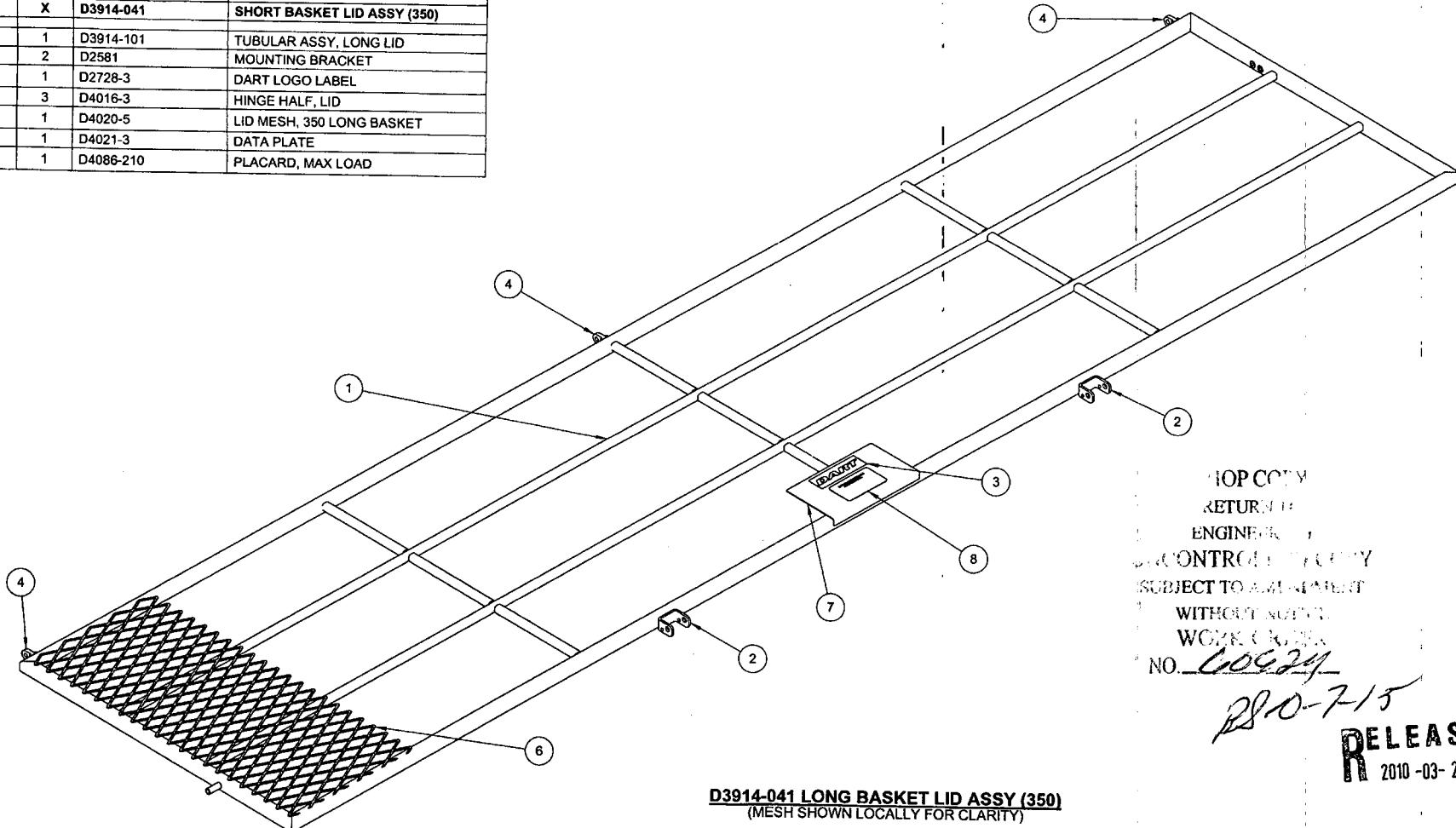
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

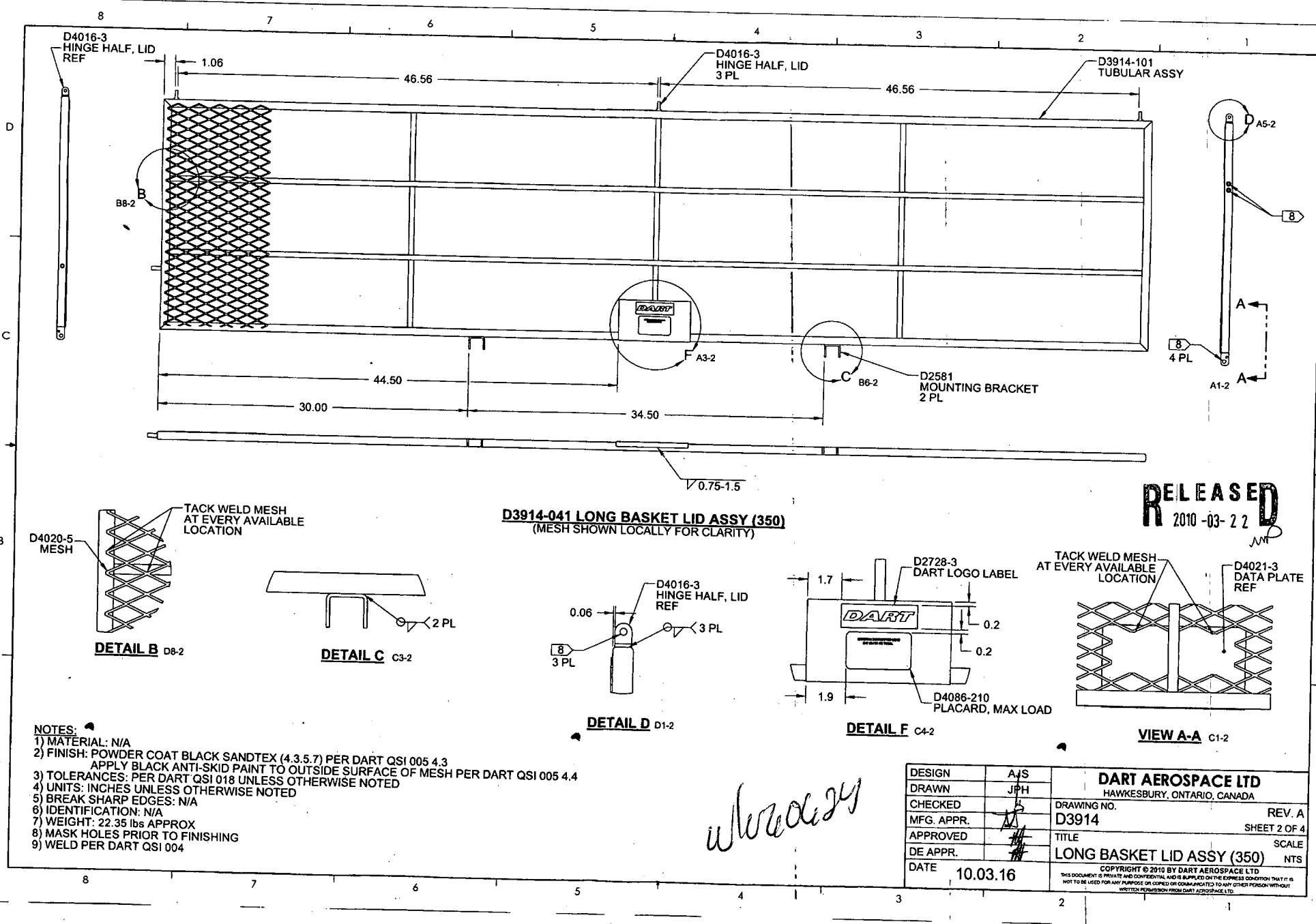
REV.	NEW ISSUE		JPH	10.03.16
	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	1	DRAWING NO.	REV. A	
MFG. APPR.	1	D3914	SHEET 1 OF 4	
APPROVED	1	TITLE	SCALE	
DE APPR.	1	LONG BASKET LID ASSY (350)	NTS	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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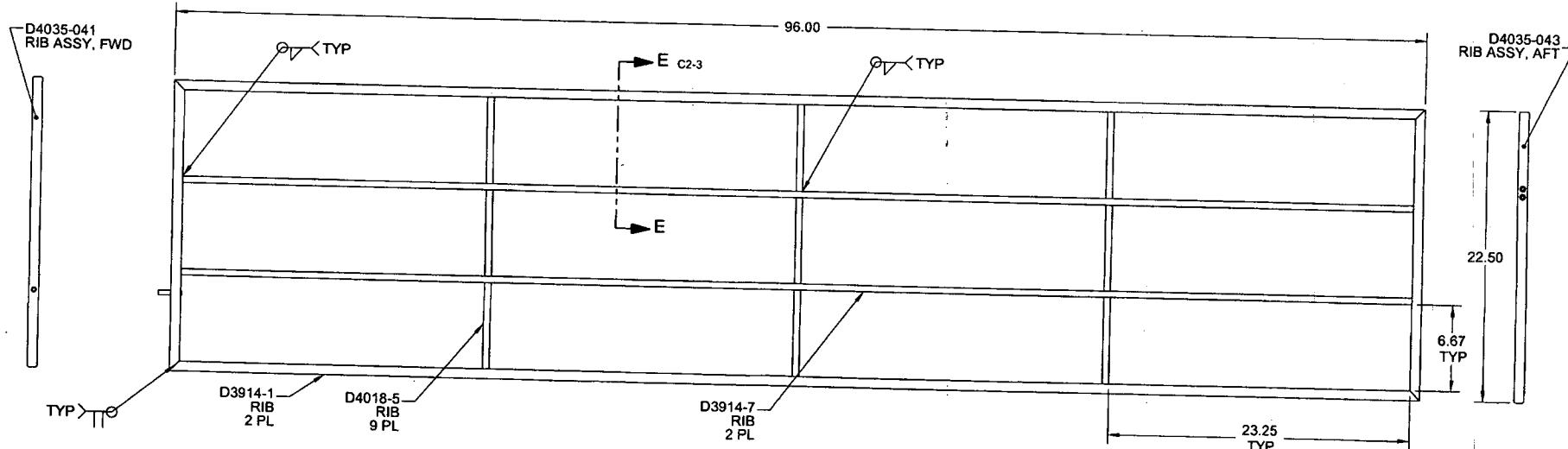
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ITEM	QTY	P/N	DESCRIPTION
	-101		
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED
2010-03-22
WAD

8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 14.10 lbs
 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 9) WELD PER DART QSI 004

WAD 10.03.16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 3 OF 4
APPROVED		TITLE	
DE APPR.		SCALE	
DATE	10.03.16	LONG BASKET LID ASSY (350) NTS	

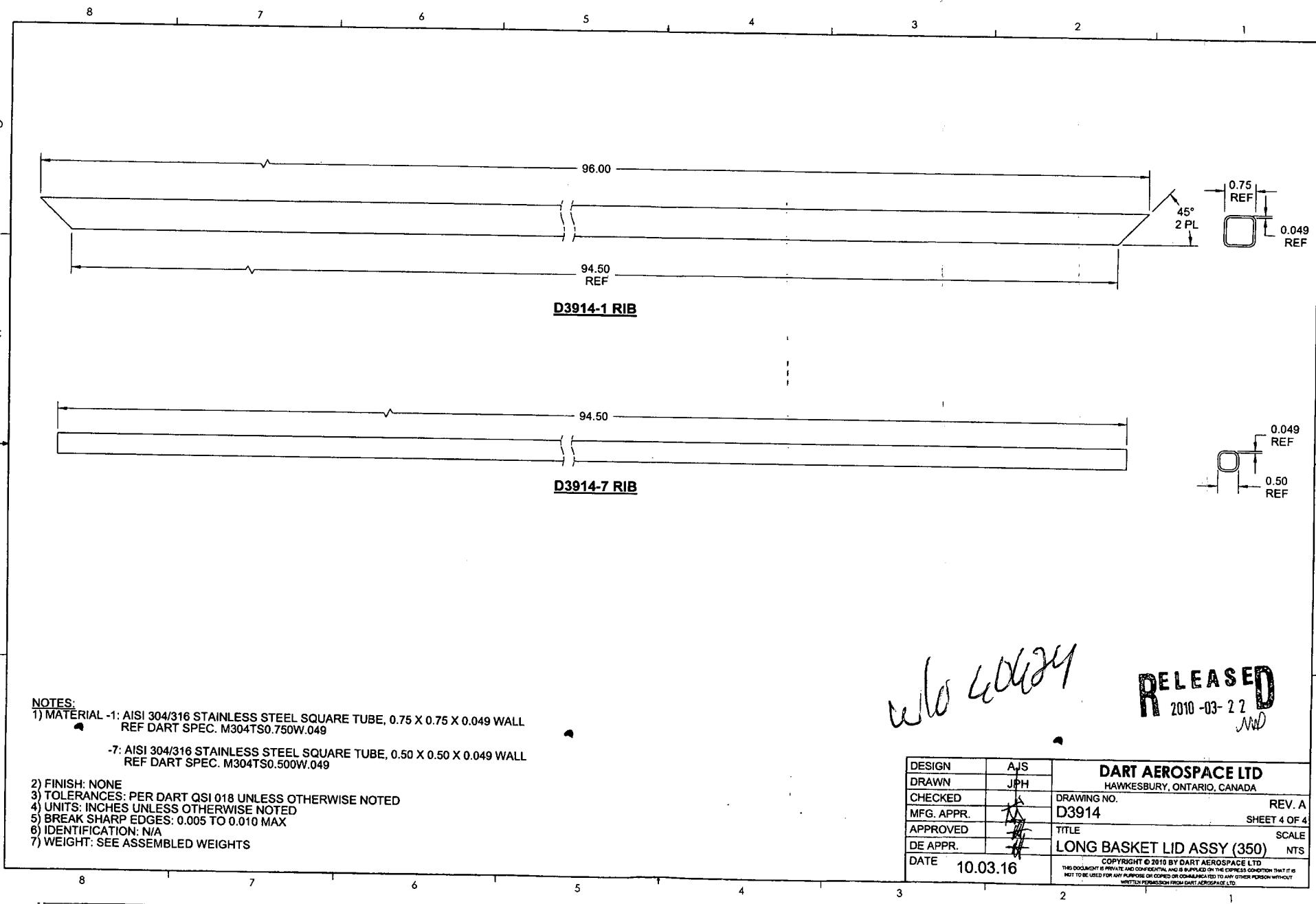
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